IN THE SPECIFICATION:

For the purposes of line numbers referred to herein, lines of text as well as blank lines between paragraphs are counted. Accordingly, beginning the numbering with the first line of the text after the title, the second paragraph on page 1, for example, is designated herein as beginning at line 4 of the text as originally filed.

On page 1, please delete all of the text appearing before the title of the invention, as well as the horizontal lines appearing before and after the title.

On page 1, before line 1 of the text and after the title, please insert the following headings:

--BACKGROUND OF THE INVENTION

1. FIELD OF THE INVENTION--.

On page 1, please amend the first paragraph beginning on line 1, as follows:

--The present invention relates to a process for the correction of the longitudinal registration error of a rotary printing press with several inking systems in which a control

unit adjusts the desired application line of the printing plate on the material web lying on one of the two rollers by controlling the drive or drives of the two rollers directly involved in the printing process of an inking system, so that the two rollers have, at least during a period of time, a different circumferential speed ~~according to the preamble of claim 1~~.--

On page 1, line 3, please insert the following heading: --2. DESCRIPTION OF THE RELATED ART--.

On page 2, before line 8, please insert the following heading:
--SUMMARY OF THE INVENTION--.

On page 2, please amend the paragraph beginning on line 11, as follows:

--This objective is realized by ~~the characterizing clause of Claim 1~~. a process for correcting the longitudinal registration error of a rotary printing press with several inking systems in which a control unit adjusts the desired application line of the printing plate on the material web lying on one of the two rollers by controlling the drive or drives of the two

rollers directly involved in the printing process of an inking system, so that the two rollers have, at least during a period of time, a different circumferential speed. The control unit takes into account the shift of the actual, effective print line on the circumference of both rollers in the correction, which arises as a consequence of an adjustment movement of one of the two rollers involved in the printing process along an axis that does not run coincident with the connecting line of the axes of rotation of the two rollers involved in the printing process. The control unit determines correction values from the relative positions of the two rollers directly involved in the printing process and the inking system, and the angle between the connecting line of the axes of rotation of the two rollers involved in the printing process and the axis of adjustment.--

On page 5, before line 2, insert the following heading, --BRIEF DESCRIPTION OF THE DRAWINGS--.

On page 5, please amend the paragraphs beginning at lines 2, 4, 6 and 8, and add the new paragraphs thereafter, as follows:

--The following sets forth a brief description of figures ~~show~~:

Figure 1 shows, schematically, a flexographic printing press with a plurality of printing presses[[,]].

Figure 2 shows, schematically, a printing plate roller in the printing process[[,]].

Figure 3 shows, schematically, the consequences of a dynamic adjustment according to the present invention.

Figure 4 is a block diagram of the components of a printing press in accordance with the present invention.

Figure 5 is a flow chart of the process according to the present invention.

Figure 6 is a more detailed flow chart of the adjusting step of Figure 5.--

On page 5, line 9, insert the following heading along with the paragraph following thereafter:

--DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

Further scope of applicability of the present invention will become apparent from the detailed description given hereinafter. However, it should be understood that the detailed description and specific examples, while indicating preferred

embodiments of the invention, are given by way of illustration only, since various changes and modifications within the spirit and scope of the invention will become apparent to those skilled in the art from this detailed description.--.

On page 5, please amend the paragraph beginning on line 10 as follows:

--Figure 1 shows schematically the arrangement of inking systems 1 to 8 of a flexographic printing press 10 around an impression cylinder 11, where only the inking systems 1, 4, and 8 are completely represented. For the other inking systems, only the position of the printing plate rollers is specified. The inking systems are suspended on a press frame that is not represented. The inking ~~systems~~ system n (n denotes an arbitrary one of the inking systems present) includes a printing plate roller K_n and an inking system F_n. The axes of rotation of the printing plate rollers are denoted by M_n; ~~and that of~~ the axis of rotation of the impression cylinder is denoted by M_{11}. As shown, the axes of rotation M_n and the axis of rotation M_{11} are generally parallel with one another. The effective print lines between the printing plate rollers K_n and the impression cylinder 11 are denoted by D_n. The lines that ~~are defined by~~ connect the ~~axes~~

axis of rotation M_{11} and the print lines D_n are denoted by S_n. As shown, these connecting lines S_n run generally perpendicularly to the axes of rotation M_n and M_{11}. ~~Therein, D_n is the print line of the printing plate roller K_n on the impression cylinder.~~ Between the lines S_n and the axes of the adjustment movement BA_n, angles α_n arise. ~~The effective print line between the printing plate rollers K_n and the impression cylinder 11 are denoted by D_n.~~ --

On page 6, please amend the paragraph beginning on line 10, as follows:

--Figure 2 shows, in the example of a printing plate roller K_9, the position of the printing plate ~~cylinder~~ roller K_9 during the printing process. The printing plate ~~cylinder~~ roller K_9 and other materials flexibly involved in the printing process, such as the unrepresented rubber coating of the impression cylinder and the also unrepresented print substrate, are exposed to strong forces in the printing process. Thus, the print plate 12 is squeezed between the impression cylinder 11 and the printing plate roller K_9 along the print line D_9. A similar process takes place on the print line 13 between the printing plate roller K_9 and the inking system F_9. In a rapid rotation of the roller K_9 about its axis of rotation M_9, it can occur that

the deformation, among other things, of the printing plate on the aforementioned print lines [[K_9]] $\underline{D_9}$ and 13 is no longer moistened by the restoring forces of the squeezed material 11, 12, K_9, $\underline{F_9}$ before the squeezed material once again reaches the print lines D_9 or [[D_n]] 13. Thus, in this case, the effective radius R_{eff}, which denotes the distance between the outer circumference of the printing plate and the axis of rotation M_9 immediately before the repeated reaching of the print line D_9, is reduced. However, this effective radius R_{eff} is decisive for the quality of the printing process. In the case described above of the shrinking of the effective radius, the physical pressure on the print line can lessen and an effect on the ink transfer to the print substrate can occur. In this case, the press operator or the press control of a flexographic printing press will set the printing plate roller more strongly on the impression cylinder 11.--

On page 7, after the last line, please insert the following new paragraphs:

--Figure 4 sets forth the components of a printing press in accordance with the present invention including at least two rollers 11, K, and an inking system F, as are depicted in

Figure 1. In addition, at least one drive unit 20 is associated with at least one of the rollers, the drive unit 20 being controlled by the control unit 22. The control unit 22 determines correction values for correcting longitudinal registration error and, in doing so, may access correction values from a storage device 24 or use a computer 26 running a computational algorithm. The control unit 22 may also perform a preregistration by evaluating the relative positions of the components of the print images that are plotted by optical sensors 28. The relative positions plotted by the optical sensors 28 may also be used by the control unit to perform registration corrections at regular intervals of time.

Figure 5 summarizes the process for correcting a longitudinal registration error of a rotary printing press having a plurality of inking systems F_n, at least two rollers 11, K_n having respective axes of rotation M_n, M_{11} joined by a connecting line S_n and being directly involved in the printing process of an inking system, and a control unit 22, according to the present invention. As shown, the process includes performing a preregistration, step 100, by evaluating the relative positions of components of the print image. The process then includes controlling, step 110, a drive of two rollers directly involved

in the printing process so that, at least during a period of time, the rollers have different circumferential speeds. The process further includes adjusting by the control unit, step 120, a desired print line of the printing plate on a material web lying on one of the two rollers. A further step may be undertaken by the control unit which includes performing, step 130, a registration correction by evaluating the relative positions of components of the print image at regular intervals of time. In both of steps 100 and 130, the relative positions of components of the print image may be provided to the control unit by optical sensors.

As further defined in Figure 6, step 120 includes the steps of taking into account by the control unit, step 122, a shift (A) of the actual, effective print line on the circumference of both rollers 11, K_n arising as a consequence of an adjustment movement of one of the two rollers along an adjustment axis BA_n that does not run coincident with the connecting line S_n of the axes of rotation M_n, M_{11} of the two rollers but is at an angle thereto. The method may include accessing, step 124, correction values on a storage device 24, or accessing, step 126, correction values on a computer unit 26 running a computational algorithm. The method then includes

determining by the control unit, step 128, values for correcting any longitudinal registration error in the print line from the relative positions of the two rollers and the inking system, and the angle α between the connecting line S_n of the axes of rotation and the adjustment axis BA_n.

The invention being thus described, it will be apparent that the same may be varied in many ways. Such variations are not to be regarded as a departure from the spirit and scope of the invention, and all such modifications as would be recognized by one skilled in the art are intended to be included within the scope of the following claims.--.

Delete pages 8 and 9 in their entirety.